

Date: Monday, 10/30/2006 4:12:54 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 SKIDTUBE
Job Number	: 29221		
Estimate Number	: 11650		
P.O. Number	: N/A	Part Number	: D058672012
This Issue	: 10/30/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 29220	Material	: N/A
Written By	: <u>JA</u>	Due Date	: 11/30/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 061031</u>		
Comment	: Est Rev:G 0206.27 Re-format; CHG002 (MPP 2251); ECN 258 K J		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-012 CHG002

KS 061031 ①

2.0

29221A

OH-58 SKIDTUBE ASSEMBLY



Comment: Sub-Component 1 D058-672-041 OH-58 SKIDTUBE ASSEMBLY B29221A

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2968-043 Tow Ring B28865

PU6/12/08

5.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2935 Saddle Spacer B28265

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 29221

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2934

Saddle Spacer

B28269

7.0

D29332

206 Saddle Right



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2933-2

Saddle

B28938 1x ✓ B28263 1x -

8.0

D29322

206 Saddle Right side



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2932-2

Saddle

B28261 1x ✓ B28407 1x -

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 10 D2712

Set Screw

B26481 -

10.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2659

Lug Assembly

B28857 -

11.0

D2652

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 24 D2652

Bushing

B28402 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 29221

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN3-37A Bolt M14978-

13.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN3-41A Bolt M102658

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-6A Bolt M102602-

15.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-10A Bolt M101890-

16.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-12A Bolt M101943-

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 29221

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 12 AN960JD10

Washer

M100743 -

18.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 24 AN960JD416

Washer

M102339 -

19.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 8 AN960JD516

Washer

M100564 -

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 1 AN970-4

Washer

M100151 -

21.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 12 MS21042L3

Nut (or -3)

M101917 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 29221

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

13 MS21042L4

Nut (or -4)

M19185

10/4/11/21

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



MISSING TOWRING
D2968-043
for 100% compl.

Comment: INSPECT 100% KITS FOR COMPLETENESS

10/20/11/28

B28865

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-012

Location:

PPP Rev:

A

10/6/12/8

D

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/26/12/11

Job Completion



C206112111

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Monday, 10/30/2006 4:13:24 PM
 er: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 0H-58 SKIDTUBE ASSEMBLY
 Job Number : 29221A
 Estimate Number : 10475
 P.O. Number : N/A Part Number : D058672041
 This Issue : 10/30/2006 S.O. No. : N/A Drawing Number : D2922 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A1
 Previous Run : 29220A Material : N/A
 Due Date : 11/30/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *061031*
 Comment : Est Rev:C 02.06.28 Re-format; ECN 258 KJ
 Est Rev:D 06.02.06 Added Dt8025 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2620 Bent Tube 3" OD

Batch

228932 BE 06-11-03

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

*m101010/m 101655 BE 06-11-03*3-Cut aft end of D2620 bent tube as per dwg D2922 *m-q 06/11/06 ①*4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia. *m-q 06/11/07 ①*5-Drill holes for wearplates using DT 8487 Open to 0.297" dia. *m-q 06/11/07 ①*6-Drill holes for aft cap, as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit *m-q 06/11/07 ①*8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 *pm 06-11-07 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr and Blow out all chips form inside the tube

pm 06-11-7 ①

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-A 06/11/07 ①

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2923

Web

B29229

M-A 06/11/11 ①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

M-A 06/11/11 ①

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

M-A 06/11/11 ①

3-Deburr and Blow out all chips from inside the tube

M-A 06/11/11 ①

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R

Sikaflex-291

M102107

Sikaflex expire date: *07-02-01*

M-A 06/11/11 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-11-15

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14400

BE 06-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:13:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number Description Batch
22 D2649 Crossbolt spacer

28648 - BE 06-11-15

PTO - 5

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M10101:0 BE 06-11-15

3-Grind welds flush as per Dwg D2922

Pm' 06-11-16 ①

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

Pm' 06-11-16 ①

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06/11/17 ①

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MA 06/11/17 ①

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06/11/23 ①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 23 ①

15.0

D2648

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch
5 D2648-3 Wearpad

29123

am 06/11/23 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-15	9	took 2 x 02649 B 28648 for weld test	BE	06-11-15	2		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:13:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe 024845

17.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-21 Wearshoe 027075

18.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2924 Wearshoe 027927

19.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 MS27039-1-08 Screw M102404

20.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 AN960JD10L Washer M102217

am 06/11/23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Monday, 10/30/2006 4:13:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 ALS4-1032-130 Insert

118990

or (see QSI 017)

22.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-1 Plugs

328691

23.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-3 O-Rings

328692

24.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

328041

25.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

1102404

a.m. 06/11/23 ① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M102217

a.m 06/11/23 ① ✓

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 02/07

M102660

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive.Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02/07

M102660

a.m 06/11/23 ①

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

102635

Batch: 06/11/23 ✓

28.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/11/23 ① ✓

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/23 ① ✓

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

M/G ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 29221A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
Dad/12/11

Job Completion



C206/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	01.08.20	Ø0.640 WAS Ø0.625	

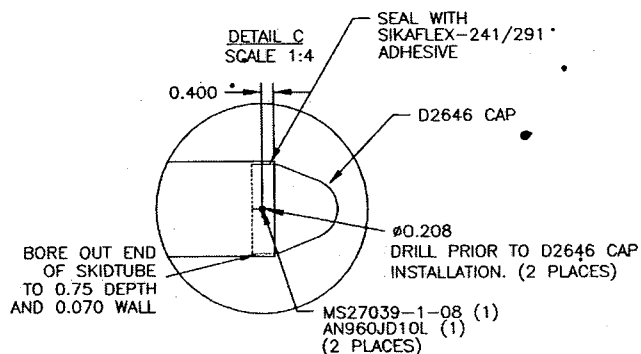
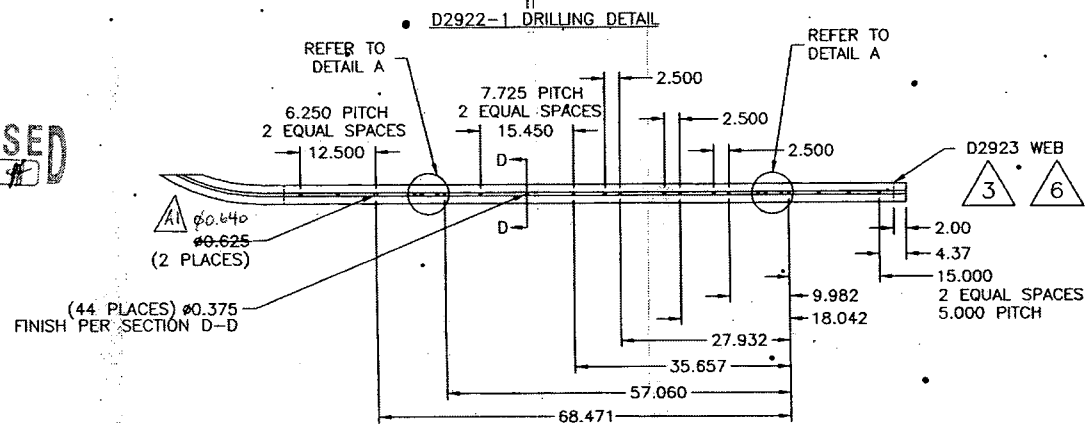
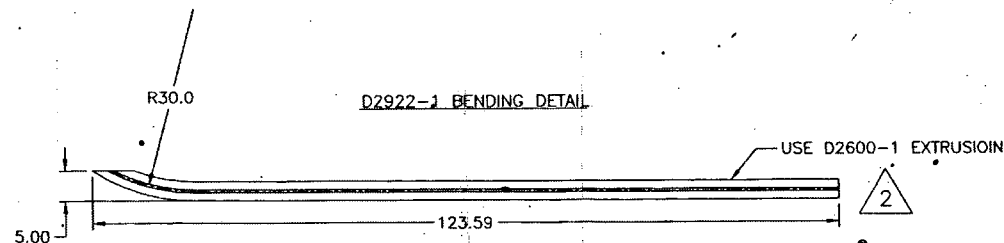
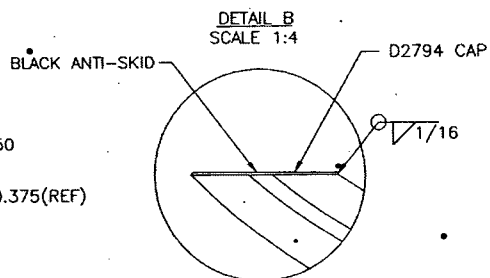
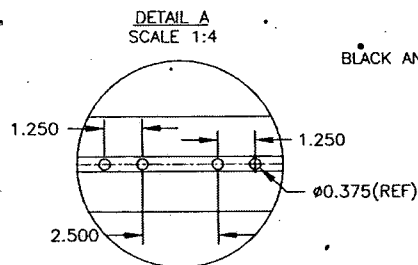
RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION -
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

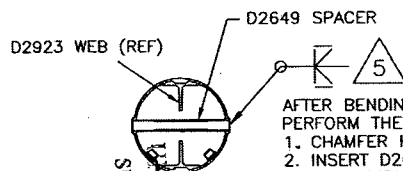
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

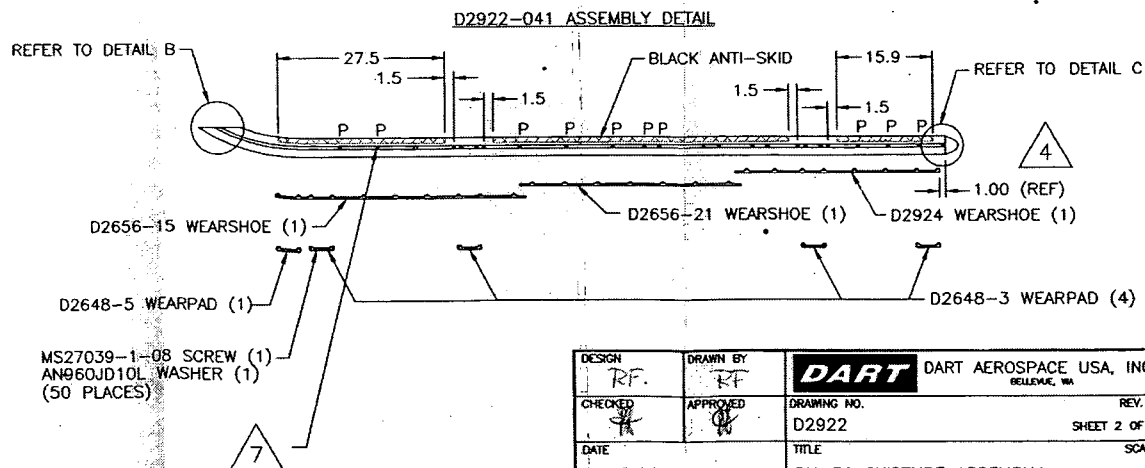
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NO. 29221A



SECTION D-D
SCALE 1:4
FOR 0.375 HOLES ONLY



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER (22 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2649 SPACER TO 0.313 X 0.75 DEEP



MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(50 PLACES)

DESIGN RF.	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE 1:20	

RELEASED
00.05.11

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NO. 75

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number NO586 72041 / B29215 A

TEST WELDS REQUIRED

BASE METAL Alun WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/15 Qualifier David A. A. A.